



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3261-1
Job Sheet 169525



Part No: D3261-1

Job Qty: 6 ea

Part Name: Battery Case Tray



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A2 IPP B 04.12.02 Material no longer cut in-house KJ/JLM IPP Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Waterjet		17/12/31
100	Waterjet	6 pcs	1/11/18	1/11/18	0.00	1.24	Waterjet1		17/12/31
110	CNC Vertical Machining	6 pcs	1/12/18	1/12/18	1.43	9.68	HAAS1-3		18/01/24
120	QC	6 pcs	1/12/18	1/12/18	0.00	0.00	QC2 Machining-2		18/01/20
130	QC	6 pcs	1/12/18	1/12/18	0.00	0.00	QC8 Machining-2		18/01/20
140	Packaging	6 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3		18/01/24
150	QC21-SA	6 Ea	1/12/18	1/12/18	0.00	0.00	QC21		18/01/24

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB750	11	67	0	0

Part Specifications

Specifications could not be found.

Plex 12/13/17 11:07 AM dart.poulin.mario

WORK ORDER NON-CONFORMANCE / UPDATE

Date: _____

Date: _____

Work Order update only ☐

Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Quality ☐ Other ☐																																							
Date : _____ Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com																																							
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PART NO: Revision: Operation: Change No:		Mfg Date: 12/31/17 Job No: 169525																																							
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		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence																																							

AEROSPACE LTD	Work Order:	169525
Description: Battery Case Tray (Dual Battery Rack)	Part Number:	D3261-1
Inspection Dwg: D3261 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	✓			
18.00	+/-0.005	18.00	✓		Ver	ED6
12.25	+/-0.030	12.25	✓			
9.75	+/-0.030	9.740	✓		Ver	CNC-02
1.27	+/-0.030	1.275	U		Ver	ED2
11.00	+/-0.030	11.00	U		Ver	CNC-02
Ø0.191	+0.005/-0.001	0.191	✓		GPR	
0.50	+/-0.010	0.508	✓		Ver	ED6
0.49	+/-0.03	0.485	✓		Ver	ED6
2.00	+/-0.010	2.00	✓		"	"
10.00	+/-0.010	9.990	U		Ver	CNC-02
1.00	+/-0.010	1.01	✓		Ver	ED6
2.13	+/-0.010	2.135	✓		"	"
Ø0.386	+0.005/-0.001	0.386	✓		G-P	
4.00	+/-0.005	4.00	✓		Ver	ED-2
0.75	+/-0.030	0.760	✓		Ver	"
0.125	-0.010/+0.030	0.135	✓		Mic	118-120
0.55	+/-0.030	0.55	U		Ver	ED-6
0.50	+0.000/-0.030	0.485	U		Ver	ED-6
0.67	+0.000/-0.030	0.655	U		Ver	ED-6

Measured by: SC/P	Audited by:	Prototype Approval:	N/A
Date: 18/01/17	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49 +/-0.010 was 0.610 +/-0.03	KJ/JLM	
C	08.11.27	0.67 dimension added	KJ/EC	

DQA: _____ Date: _____

QA Closed: MM Date: _____

FEB - 9 2018

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>D3261-1</u> Part No. <u>169521</u> NCR No. <u>18-6762</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date: <u>18/01/18</u>	Step #: <u>110</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval DAS 9 9-8- <u>18-01-19</u>																		
Description Work Order Deviation		Disposition		Completed By <u>mmk</u> <u>17/01/18</u>																	
-The top hole is off (-0.085) The part move while tightening on the Jig		Scrap destroy no replacing.		Lead hand / Supervisor Approval Verification DAS 9 9-8- <u>18-01-19</u>																	
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